

Work Order ID 62493

Page 1

Thursday, September 30, 2010 2:31:32 PM

Item ID: D3651-13

Accept



Setup Start



Revision ID:

Item Name: Outside Doubler

Stop



Start Date: 9/30/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/8/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:



Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3651	Rev B

100 B10-11-4

Waterjet FLOW WATER JET
FLOW CNC Waterjet Memo 0.00
304 .008 I-Cut as per Dwg D3651 Dwg Rev: R Prog Rev: B 2-
Deburr if necessary

110 B10-11-4

QC QC2- Inspect parts off machine FAI/FAIB Memo 0.00
Quality Control

120 S10104

QC QC8- Inspect parts - second check Memo 0.00
Quality Control

(4)

10-11-4

x4

W/O:		WORK ORDER CHANGES					
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Date:

Run

Start



QC:

Date:

SPC (Y/N):

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Stop


**Sequence ID/
Work Center ID**
**Operation
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Tool ID

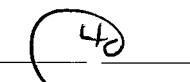
Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 100

0.00

10/11/14 5P


Packaging

Packaging

Memo

0.00

140



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

10/11/14 4P

 MF
 10-11-4

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Picklist Print

Thursday, September 30, 2010 2:31:36 PM

Page 1

Work Order ID: 62493



Parent Item: D3651-13



Parent Item Name: Outside Doubler

Start Date: 9/30/2010

Required Date: 10/8/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC
IPP Rev:B ECN 1113P 08-01-22 DD
IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S26GA 304/316 0.018 SHEET		Purchased		No		100	sf	144.0000	0.68	2.863158		BS 10-11-4	

Location	Loc Qty	Loc Code
MAT20	144	
109398	48	
112885	96	

109398

(4)

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DART AEROSPACE LTD	Work Order:	62493
Description: Outside Doubler	Part Number:	D3651-13
Inspection Dwg: D3651 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	10-11-4	Date:	10-11-04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	

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SHOP COPY

RETURN TO

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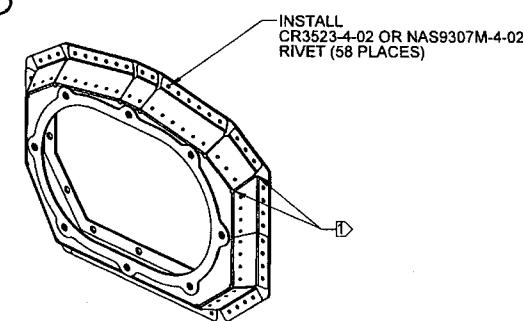
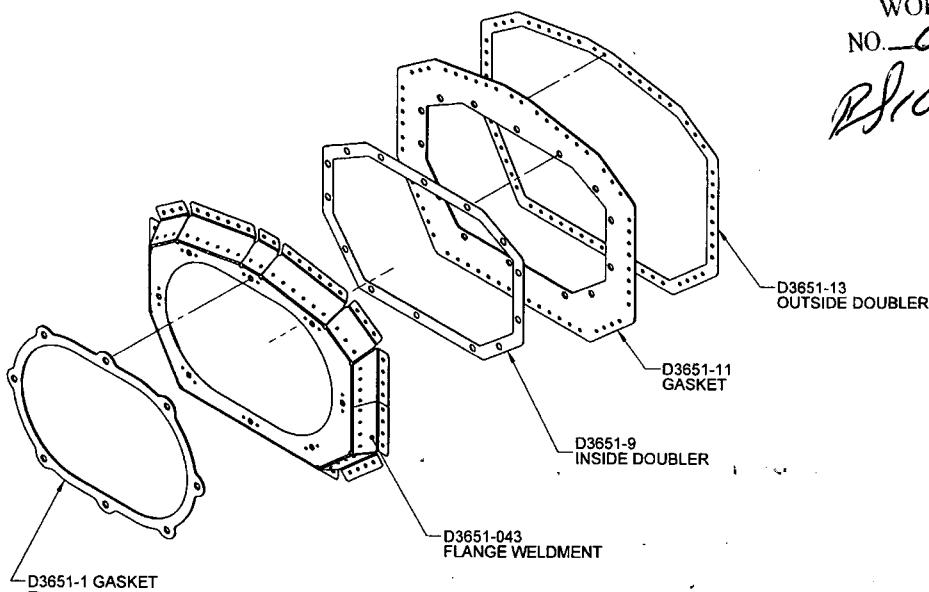
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 22193

P810-9-30



PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3651-041	AFT BASE ASSEMBLY
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

D3651-041 AFT BASE ASSEMBLY

D3651-041 NOTES:

- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.6 lbs

B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50; 0.88 WAS 0.98; REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9; GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504		RF	08.01.07
A	NEW ISSUE		RF	07.11.07
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	<p style="text-align: center;">DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA</p> <p>DRAWING NO. <u>D3651</u> REV. B SHEET 1 OF 9</p> <p>TITLE <u>AFT BASE ASSEMBLY</u> SCALE <u>1:4</u></p>		
DRAWN	RF			
CHECKED	<u>CE</u>			
MFG. APPR.	<u>NA</u>			
APPROVED	<u>AM</u>			
DE APPR.	<u>AM</u>			
DATE	08.01.07			

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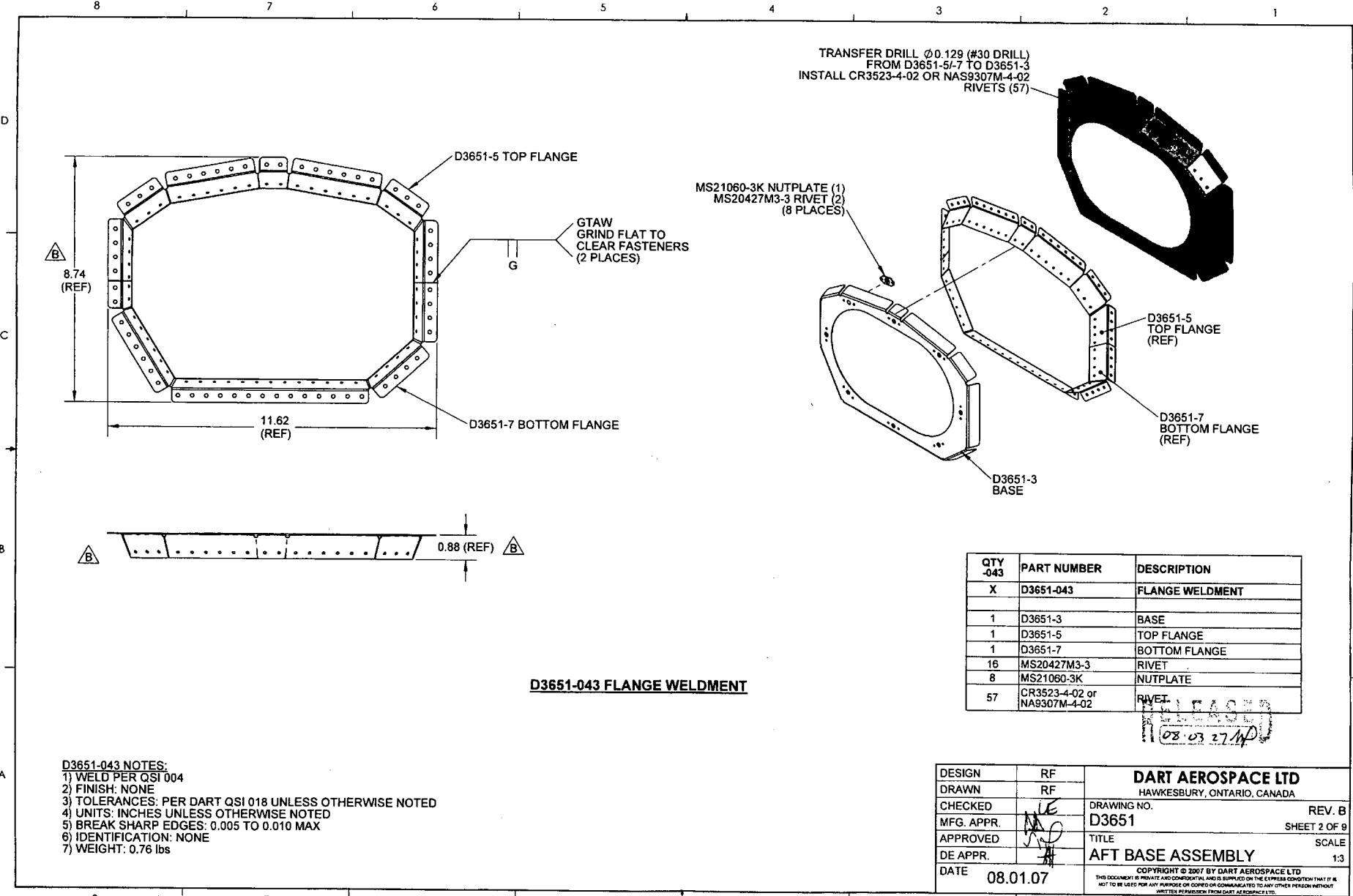
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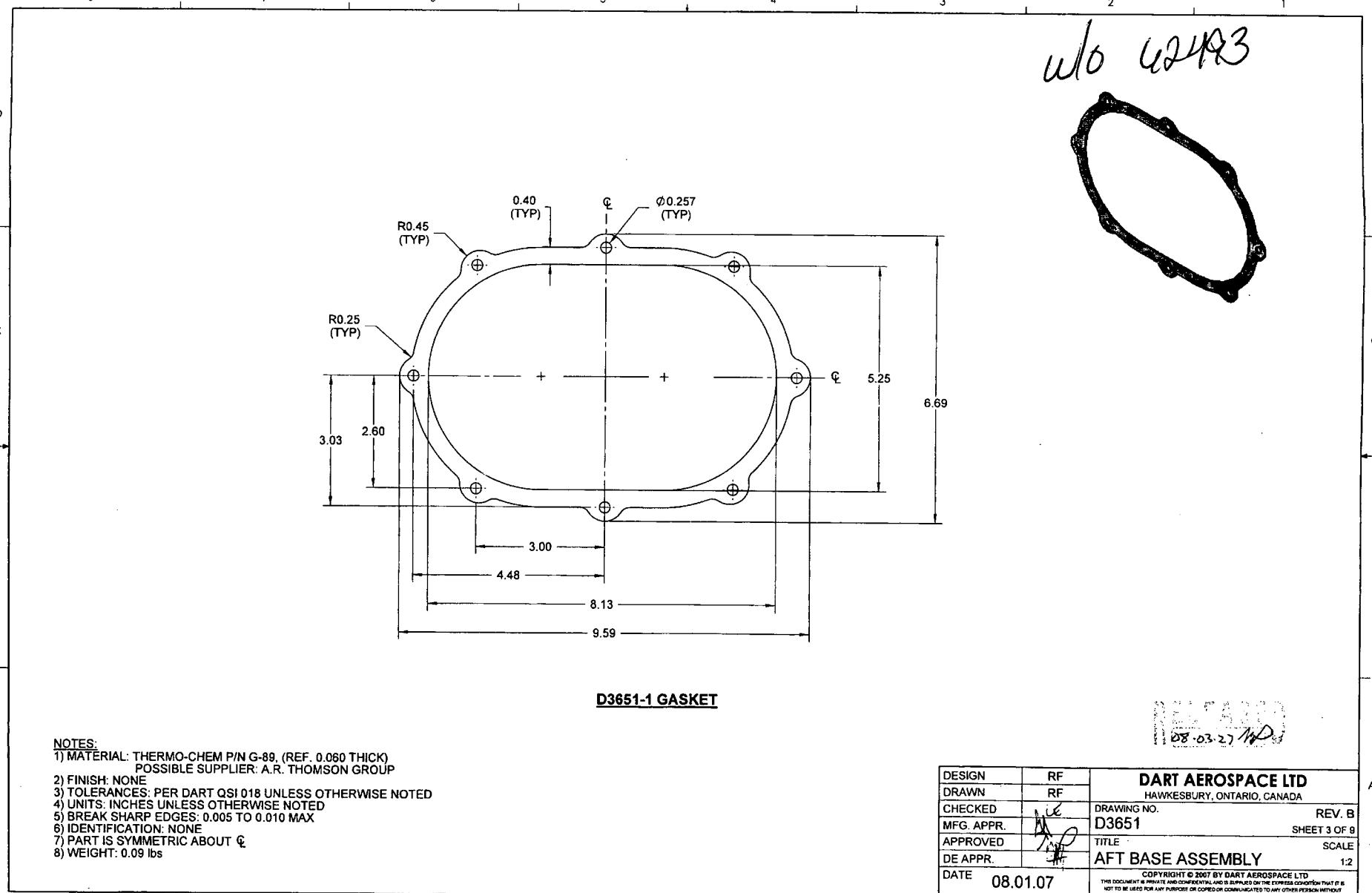
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>je</i>	DRAWING NO.	
MFG. APPR.	<i>je</i>	REV. B	
APPROVED	<i>je</i>	D3651	SHEET 3 OF 9
DE APPR.	<i>je</i>	TITLE	SCALE
DATE	08.01.07	AFT BASE ASSEMBLY	1:2

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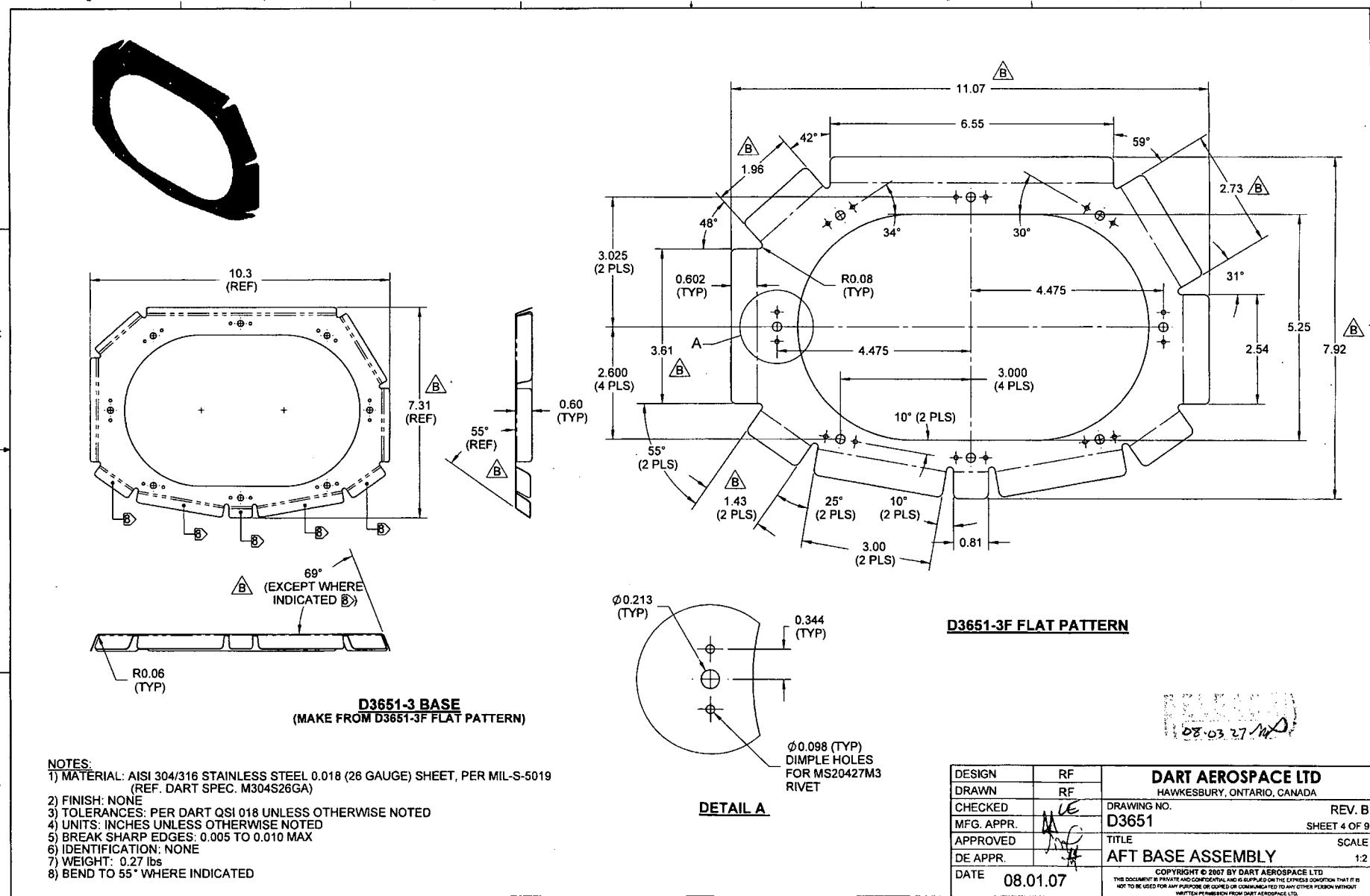
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w6 62483



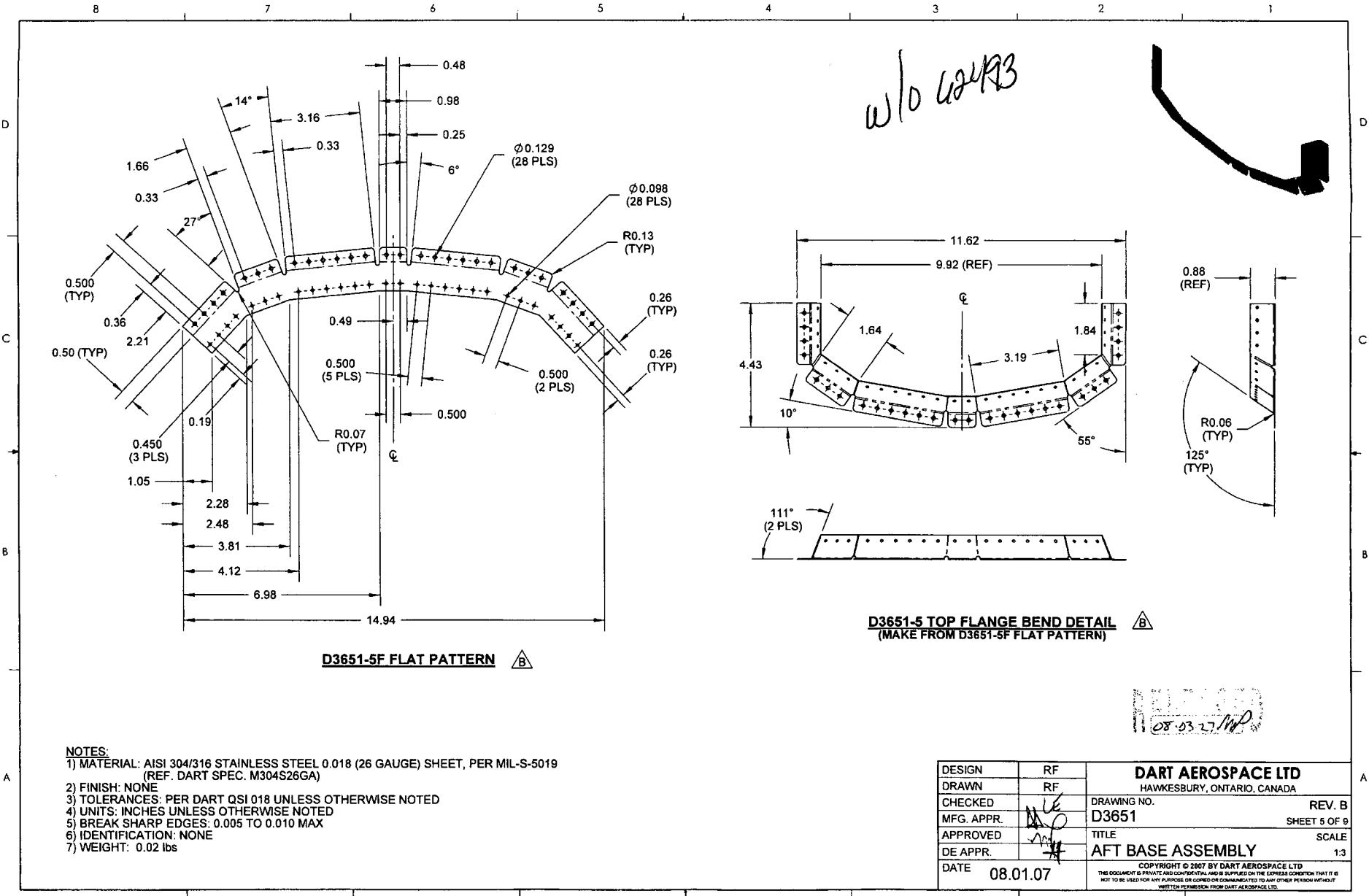
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NOTES-

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	RF			
CHECKED	<i>ME</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>ME</i>	D3651	SHEET 5 OF 9	
APPROVED	<i>ME</i>	TITLE	SCALE	
DE APPR.	<i>ME</i>	AFT BASE ASSEMBLY	1:3	
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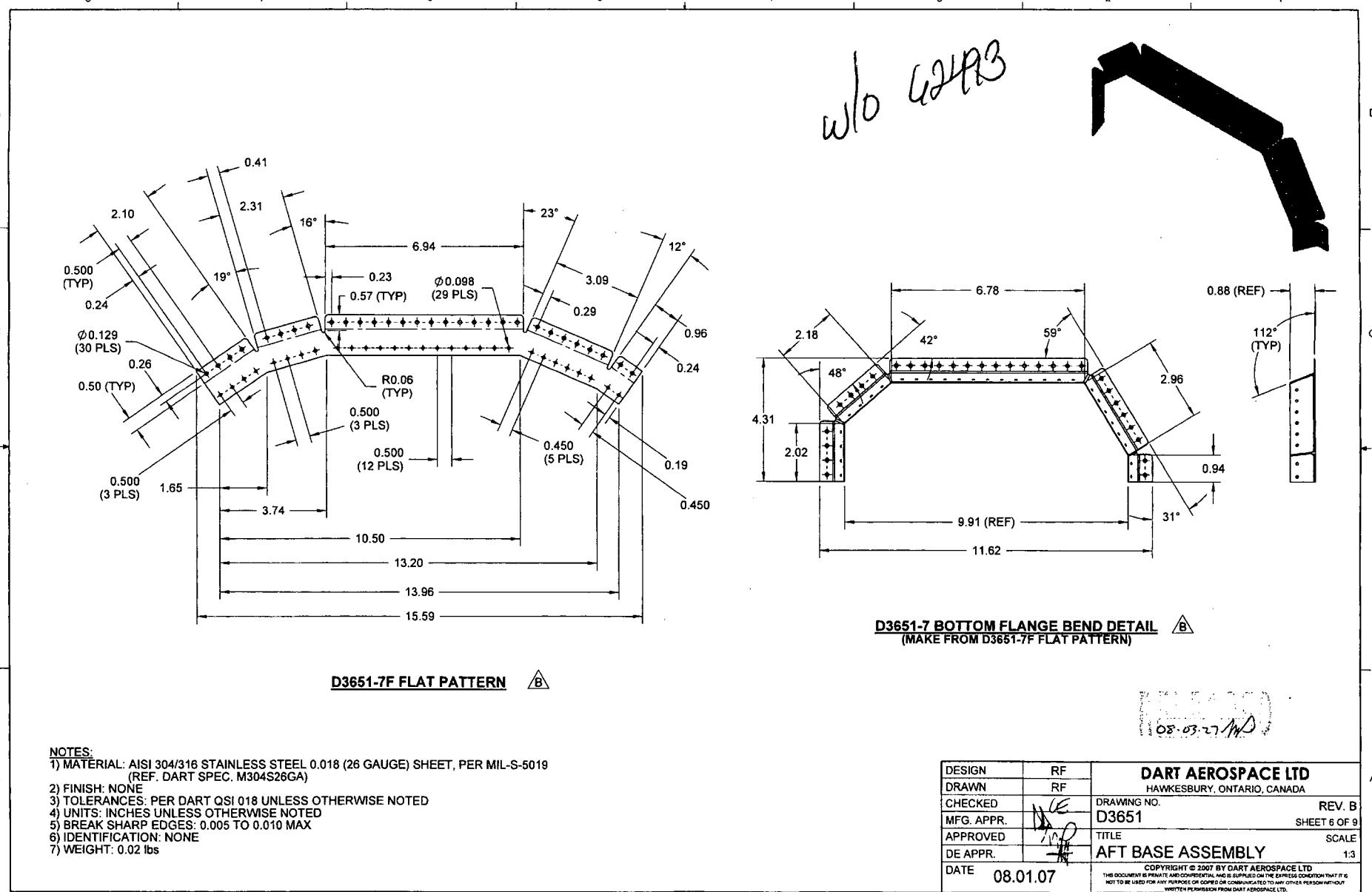
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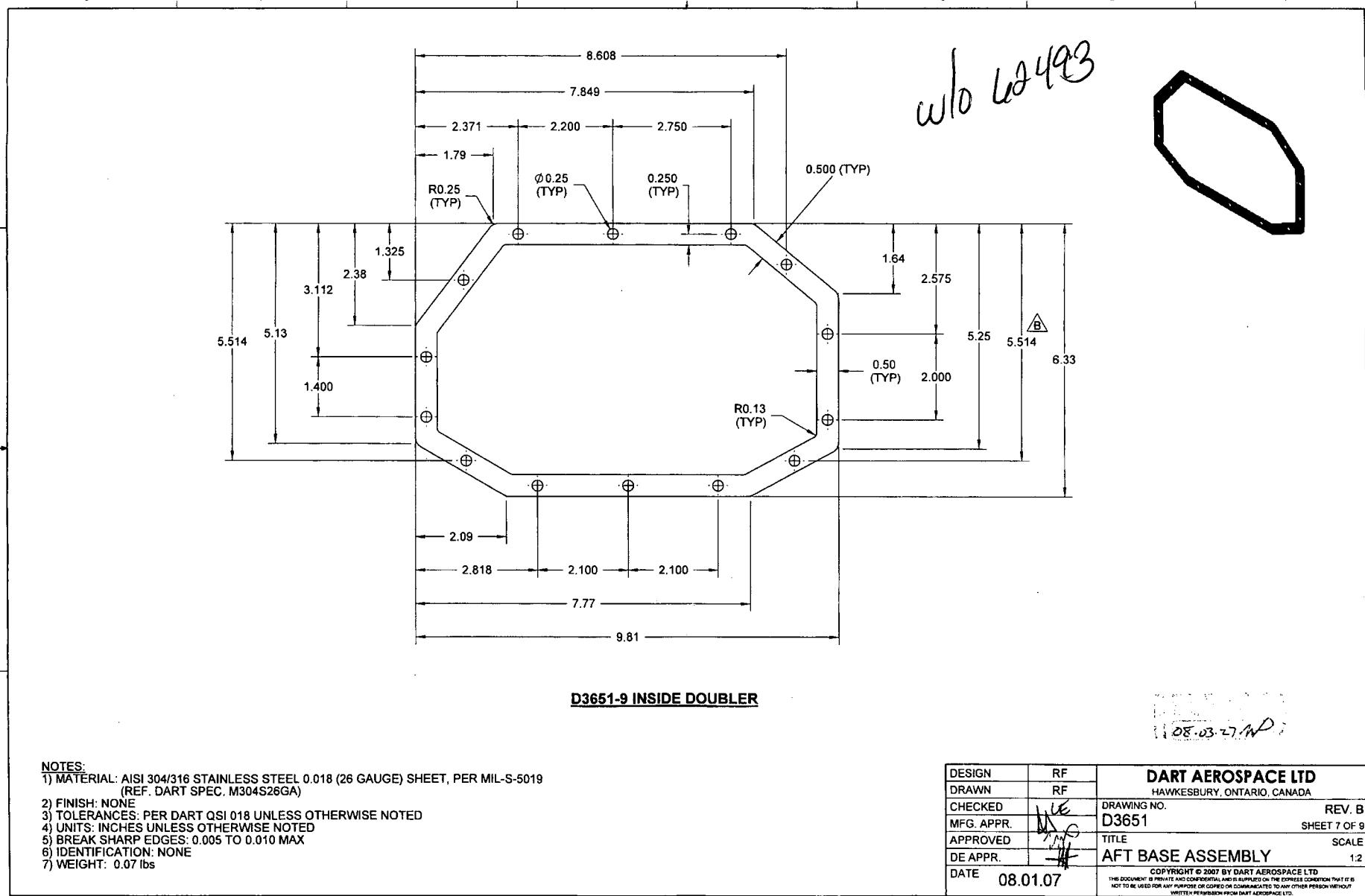
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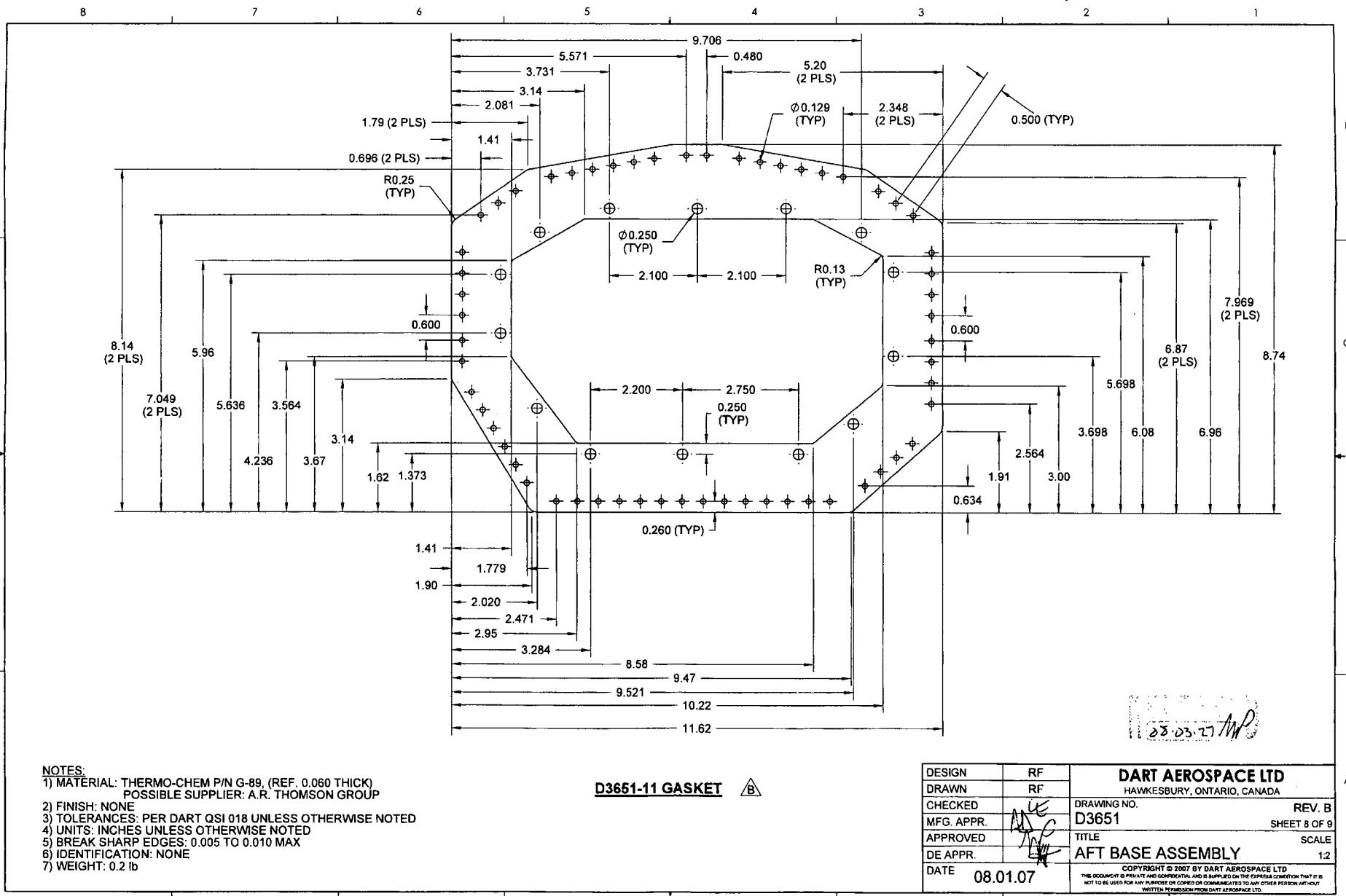
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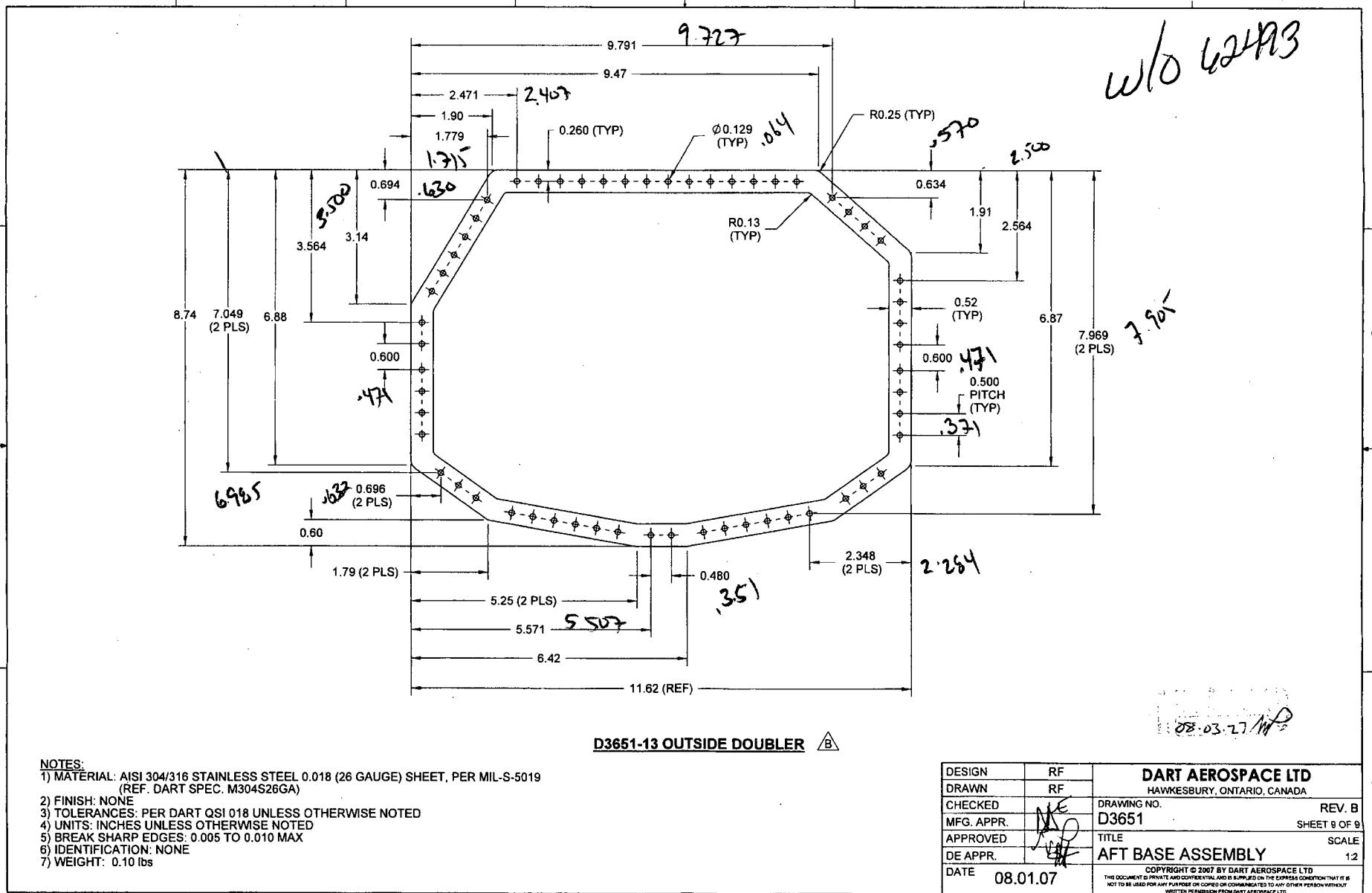
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